

Work Order ID 52903

October 19, 2009 12:37:00 PM

Page 1

Item ID: D3502-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Support

Start Date: 10/19/09 Start Qty: 40.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *09-10-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3502

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blank 3.475" long 11 BLANK MAKES 2 PARTS

1 SL 09/10/22

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA649 Rev: *B* & Dwg D3502 Rev: *B* 112-Deburr
per dwg D3502

SL 09/10/23

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL SL 09/10/23

*P70
last
page*

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Page 2

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Setup Start

Stop

Start Date: 10/19/09 Start Qty: 40.00

Required Date: 11/02/09 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

mmf
29/10/25

40

0

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Mark hole position using DT94301 IDrill as per Dwg D3502.

EP 09/10/26 (40)

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

HJ 09/10/26

(40K)

Ø

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Item ID: D3502-1

Accept

Revision ID: B

Item Name: Support

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 40.00

Required Date: 11/02/09 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:00 AM

OVEN TEMPERATURE:

FINISH TIME:

320°F

⇒ Hf 09/10/27

(X40)

Ø

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

UWD 09/10/27 X40

180

Identify as per dwg & Stock Location: 107

0.00



Packaging

Memo

0.00

Packaging

09/10/27 (40)

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Item ID: D3502-1

Accept

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Start Date: 10/19/09 Start Qty: 40.00

Required Date: 11/02/09 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-10-28
MF
09-10-27

Picklist Print

October 19, 2009 12:37:04 PM

Page 1

Work Order ID: 52903

Parent Item: D3502-1RevB

Parent Item Name: Support

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	74.3000	12.1684			



6061-T6 Bar 1.00 x 4.00

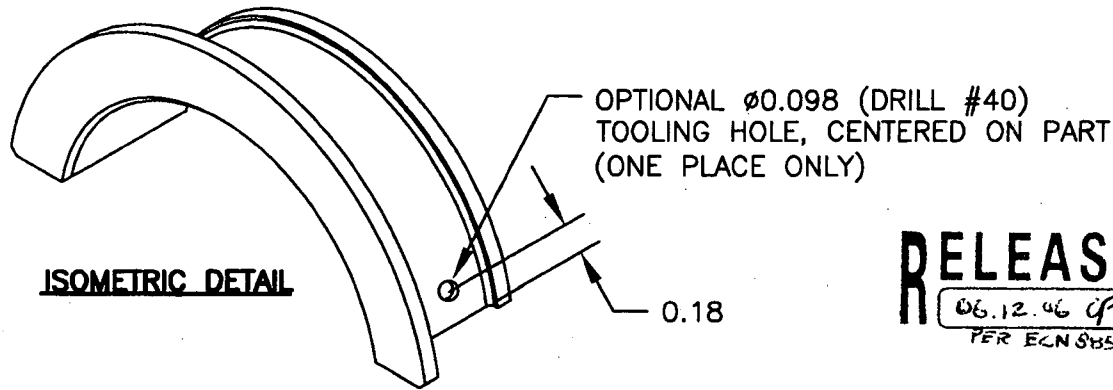


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	74.3	
107221	62.27	
11941	12.03	

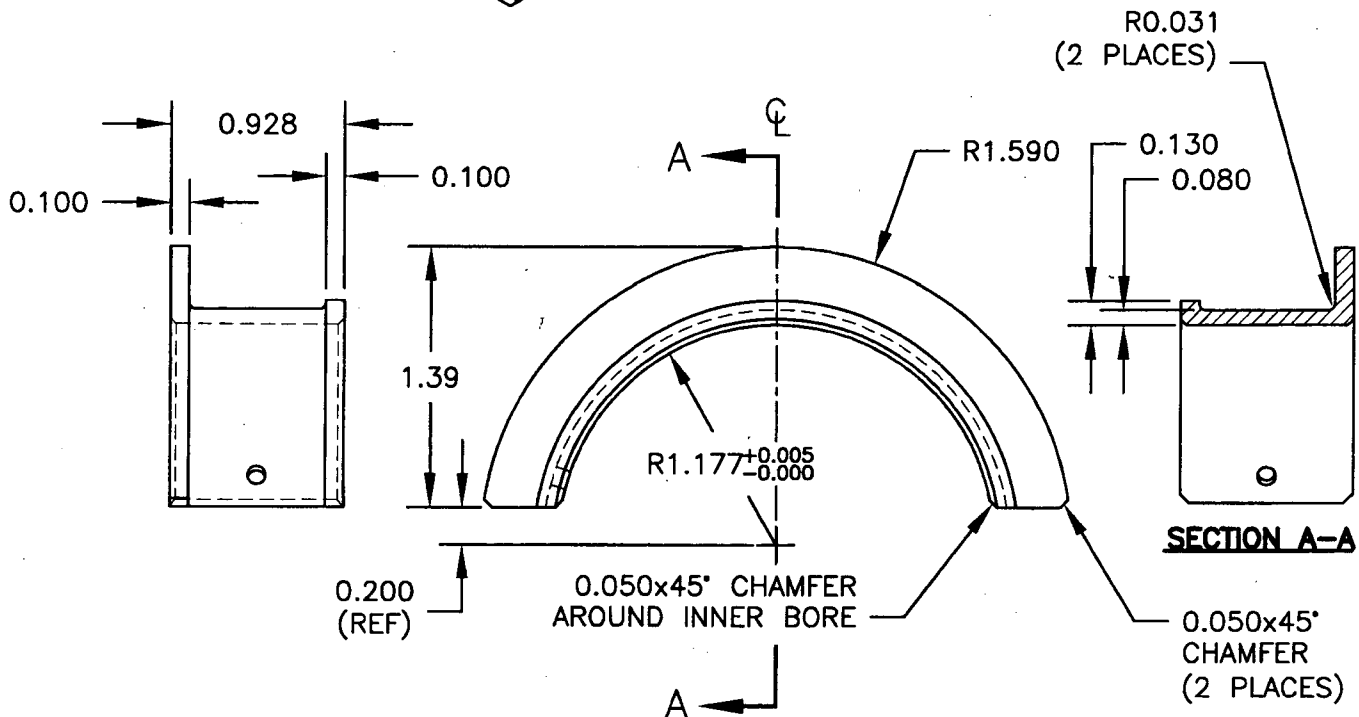
5.79 - JL 09/10/23

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



RELEASED
06.12.06 *qp*
PER ECN 885



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3




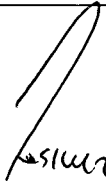

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52903
P/L 09-10-15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3502-1 PAR #: _____ Fault Category: Machined Parts NCR: Yes No DQA: / Date: 09-10-23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: 52903		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/10/23	110	- 1 part scrapped; operator put part on wrong side. Too much material removed. R.C. - operator error Lack of attention		- scrap + replace qty 1	 09/10/23	 09-10-23	 09-10-23	 09-10-23

NOTE: Date & initial all entries